

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 74.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-020231**Date Inspected:** 25-Jan-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** Goodwin Steel, UK**Location:** Trentham, UK**CWI Name:** N/A**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Cable Band**Summary of Items Observed:**

The following report is based on METS observations at Goodwin International, Trentham, UK on this date.

The QA Inspector observed measurement of the length of the suspender rope grooves on the cable band for East Panel Point 30, a B9 type 1 cable band. The locations at 180 degrees were marked out and the length was remeasured at 180 degrees. The results are:measured at

Location	measurement at 180 degrees	calculated length at 200 degrees
Top:	1568 mm	1742 mm
Bottom:	1558 mm	1731 mm

Note that measurement labeled top is actually the groove that is closest to the center column when installed.

The QA inspector reviewed a copy of the Goodwin Steel Castings "Weld Excavation Map" for casting GG29429-3(R1), B7-1-F. The Weld Excavation Map was reviewed for accuracy and compliance with contract documents. This second repair cycle is a minor repair and does not require post weld heat treatment. Caltrans Lot Number B243-022-11 was assigned for tracking purposes.

The QA inspector reviewed a copy of the Goodwin Steel Castings "Weld Excavation Map" for casting GG29436-1(R1), B9-1-M. The Weld Excavation Map was reviewed for accuracy and compliance with contract documents. This second repair cycle is a major repair and requires post weld heat treatment. Caltrans Lot Number B243-021-11 was assigned for tracking purposes.

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The QA Inspector observed welding of Casting GG29425-1, Drawing Number 5540-B5-1-F. The welding was being performed by Mr. Dan McDonagh . Mr. McDonagh was using WPS04-102F4B Issue 5. The welding was being performed at 23 volts and 157 amps. The filler metal was 4mm AWS A5.1 E 7018-1. Welding was being performed in the 1G position.

The QA inspector periodically observed that Goodwin International personnel perform finish grinding of an assembled B8 Type 1 cable band for east panel point 22 (EPP-22) consisting of castings 5540-B8-1-M-3, and 5540-B8-1-F-2, and an assembled B9 Type 1 cable band for west panel point 28 (WPP-28) consisting of castings 5540-B9-1-M-7, and 5540-B9-1-F-5. All sharp edges from the machining operations and suspender groove transitions are being ground to required finish by Goodwin International personnel.



Summary of Conversations:

Relevant conversations are documented above

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy (510) 385-5910, who represents the Office of Structural Materials for your project.

Inspected By:	Riegler,Randy	Quality Assurance Inspector
Reviewed By:	Edmondson,Fred	QA Reviewer
